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1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200
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D117-762-041
Job Sheet 201679



Part No: D117-762-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/8/19

Job Tracking No:

Due Date: 10/29/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3582 REV E IPP Rev:A 07.06.11 New Issue EC IPP Rev:B 08-02-22 change to revA as per dwg DD verF by:EC IPP REV:C 15.06.11 AS PER CHG002 DD VERF:JLM IPP REV:D 16.02.05 DWG REV:C (ecn16-514)DD VERF:JLM IPP REV:E 17.01.17 as per dwg REV:D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	Skidtubes - 1	1 pcs	10/29/19		0.00	3.30	Skidtubes - 1		00
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
140	Skidtubes - 2 - B4B	1 pcs	10/29/19		0.00	3.30	Skidtubes - 1 - B4B		GE
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
150	QC 10	1 pcs	10/29/19		0.00	0.00	QC 10 - 10		DAS NOV 07 2019 68 9-89
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
160	QC 5	1 pcs	10/29/19		0.00	0.00	QC 10 - 68		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		

Plex 10/8/19 2:59 PM Dart.lajeunesse.marie

				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	DAS
				QC 5 - 68	NOV 07 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170	Handfinish - 1-1 Chemical-B4B	1 pcs	10/29/19	0.00 0.97	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 - B4B
					Handfinish - 1 - 21 - B4B
					Handfinish - 1 - 22 - B4B
180	QC 7	1 pcs	10/29/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2

10/8/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
190 Skidtubes - 3 - B4B	1	10/29/19	0.00 3.33	Skidtubes - 1 - B4B	BB
pcs				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
200 QC 10	1	10/29/19	0.00 0.00	QC 10 - 10	
pcs				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
210 QC 5	1	10/29/19	0.00 0.00	QC 5 - 10	NOV 14 2019 68 9-89
pcs				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	NOV 14 2019 68 9-89
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
215 Handfinish - 2-1 Pressure-	1	10/29/19	0.00 0.97	Handfinish - 2 - 1 -	BB 19-11-15

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B4B		pcs				B4B	
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	
						Handfinish - 2 - 4 - B4B	
220	Powdercoat - 1 White GI(A)-B4B	1 pcs	10/29/19	0.00	0.26	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
230	QC 3	1 pcs	10/29/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
250	Handfinish - 4-1-Assembly-B4B	1 pcs	10/29/19	0.00	0.97	Handfinish - 4 - 1 - B4B	
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	

DAS
15
9-89

				Handfinish - 4 - 9 - B4B	
260 QC 5	1 pcs	10/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
270 Packaging 3-1 - Stock - B4B	1 pcs	10/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	10/29/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	

DAS
NOV 22 2019 68
9-89

DAS
21 NOV 29 2019
9-89

DAS
21 NOV 29 2019
9-89

280 QC 21 - FG

1
pcs

10/29/19 0.00 0.00

QC 21 - FG - 21

QC 21 - FG - 70

QC 21 - SA - 53

DAS

21

9-28

NOV 29 2019

Part Op 130 - Skidtubes-1 (Skidtubes) 1-Cut Aft end using DT8185 2-Deburr ends 3-Drill Aft Cap holes using DT8678 *** OPEN
 Descriptions: AFT CAP HOLE TO .187" *** 4-Locate DT 8973 from aft cap holes & Drill Ground wire hole on top of Tube. 5-Install 3/16
 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill. 6-Drill pilot holes for wearplates using DT8900 7-
 Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582. 8-Drill holes for D5520-1 doubler using DT10309 A & B,
 locating from 4th and 5th crossbolt holes from aft using .1875 clekos. Spot drill tube using #20 drill (note 10). Remove
 DT10309 B. Re-install DT 10309 A drill thru tube and doubler using #20 drill (note 10), cleko as you go. Remove .1875
 clekos and open holes in tube and doubler to 0.750". Remove doublers and identify orientation. 9-Deburr doubler and
 doubler holes in skid tube. 10-Countersink doubler holes in skid tube as per Dwg. detail J and note 12 -Touch up alodine
 on D5520-1 doublers. 11- open ground wear holes to 0.391" as per section B-B 12-Open Aft Cap holes using .209" drill.
 13-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65
 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size. 12-Do not open
 holes of section G-G to finishes size.
 140 - Skidtubes-1 (Skidtubes) 1-Weld fwd cap D2964 per dwg D3582 and QSI 004 A/R AL ROD
 Batch: 138989/139011 2-Grind flush
 150 - QC10 (QC10- Inspect visual per QSI004- ground welds)
 160 - QC5 (QC5- Inspect part completeness to step on W/O)
 170 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)
 180 - QC7-1 (QC7-Inspect Chemical Conversion Coat)
 190 - Skidtubes-1 (Skidtubes) ***MASK OFF HOLES OF SECTION F-F (DO NOT C'SINK) 1-Open X-Bolt holes to finish
 size as per Dwg D3582, sections D-D, E-E, G-G as per Dwg. 2-Counter Sink X-BOLT holes as per Dwg D3582 D-D, E-E
 and G-G.***Do NOT countersink holes of section F-F). 3-Deburr and blow out chips from inside of tube, prep. tube for
 welding. 4-Install doublers using DT10309 B. Shave rivets as required. 5-Bond web as per Dwg D3582 & QSI 015 A/R
 241 Sika Flex Batch: 5200625 Exp Date: 07/25/2020 6- Swage x-bolt spacer as per dwg and
 Section F-F QSI002. 7-Weld x-bolt spacers as per Dwg D3582 section D-D, E-E and G-G. A/R AL ROD
 Batch: 138189 8-Grind welds flush
 200 - QC10 (QC10- Inspect visual per QSI004- ground welds)
 210 - (QC5- Inspect part completeness to step on W/O)
 215 - HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Touch-up alodine as per QSI
 220- Powdercoat1 (White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum) START TIME 11:30 OVEN TEMPERATURE:
550 FINISH TIME: 12:00 11/21/88
 230 - (QC3- Inspect Part Finish)
 250 - HandFinish4 (Assemble as per dwg) 1-Inspect for Foreign objects 2-Install Aft cap as per Dwg D3582, Detail "C"
 A/R 241 Sika Flex Batch: _____ Exp Date: _____ 3-Install Wearplates as per Dwg D3582 ,
 Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582 *****Do not install
 bolts where indicated on Dwg(Note #6)***** 4- Wing Walk as per Dwg D3582 and QSI 005 4.4
 260 - (QC5- Inspect part completeness to step on W/O)
 270 - Identify and pack for shipping as per PPP D117-762-041 Location :FG081
 275 - (Document Control) Photocopy bluefile & type labels per PPP D117-762-041 CHG003
 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3582-1-BENT	Skidtube Assembly BK117	1 pcs (1 ea)	130-Skidtubes - 1	5221390
D5520-1	Doubler	2 pcs (2 ea)	130-Skidtubes - 1	508923
D2964	Cap	1 pcs (1 ea)	140-Skidtubes - 2 - B4B	5176506
CR3212-5-05	Rivet	68 pcs (68 ea)	190-Skidtubes - 3 - B4B	5226174
D2971	Cross Bolt Spacer	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5097024
D3584-1	Web	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5225755
D3662-1	Crossbolt Spacer	3 pcs (3 ea)	190-Skidtubes - 3 - B4B	5214249
D3662-3	Crossbolt Spacer	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	5173690
D5304-1	Crossbolt Spacer	2 pcs (2 ea)	190-Skidtubes - 3 - B4B	5216345
ALS4-1032-130	Rivnut	36 Ea (36 ea)	250-Handfinish - 4-1-Assembly-B4B	5057257
ALS4-428-165	Insert	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5147561
AN3-5A	Bolt	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5216385
AN3C4A	Bolt	28 Ea (28 ea)	250-Handfinish - 4-1-Assembly-B4B	5229681
AN4-4A	Bolt	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5193116
D2965	Cap	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5166570
D3508-11	Wearplate Aft Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5172981
D3508-13	Wearplate Aft	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5172982
D3508-3	Wearplate Fwd Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5172577
D3508-9	Wearplate Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5172977
D3558-11	Gasket Aft Center	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5210680
D3558-13	Gasket Aft	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5224210
D3558-3	Gasket Center Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5210684
D3558-9	Gasket Fwd	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	5210687
NAS1149C0332R	Washer (AN960C10L)	28 Ea (28 ea)	250-Handfinish - 4-1-Assembly-B4B	5226629
NAS1149D0332J	Washer	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5170378
NAS1149D0416J	Washer	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5113151

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
130-Skidtubes - 1	D3582-1-BENT	1	3	0
	D5520-1	2	42	0
140-Skidtubes - 2 - B4B	D2964	1	22	0
	CR3212-5-05	68	444	0
190-Skidtubes - 3 - B4B	D2971	1	63	0
	D3584-1	1	5	0
	D3662-1	3	119	0
	D3662-3	1	36	0
	D5304-1	2	37	0
	ALS4-1032-130	36	5,708	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-428-165	2	68	0
	AN3-5A	2	266	0
	AN3C4A	28	1,464	0
	AN4-4A	2	37	0
	D2965	1	50	0
	D3508-11	1	11	0
	D3508-13	1	7	0
	D3508-3	1	14	0
	D3508-9	1	12	0
	D3558-11	1	11	0
	D3558-13	1	3	0
	D3558-3	1	12	0
	D3558-9	1	12	0
	NAS1149C0332R	28	3,974	0
	NAS1149D0332J	2	1,265	0
	NAS1149D0416J	2	1,739	0

Part Specifications

Specifications could not be found.

ITEM	Qty	Part Number	Description
	X	D3582-041	SKIDTUBE ASSEMBLY
1	1	D2582-150	EXTRUSION
2	1	D2584	CAP
3	1	D2585	CAP
4	1	D2571	CROSS BOLT SPACER
5	1	D3508-3	WEARPLATE
6	1	D3508-9	WEARPLATE
7	1	D3508-11	WEARPLATE
8	1	D3508-13	WEARPLATE
9	1	D3508-3	GASKET
10	1	D3558-9	GASKET
11	1	D3558-11	GASKET
12	1	D3558-13	GASKET
13	1	D3584-1	WEB
14	3	D3582-1	CROSS BOLT SPACER
15	1	D3582-3	CROSS BOLT SPACER
16	2	D3504-1	CROSS BOLT SPACER
17	2	D5520-1	DOUBLER
18	28	AN3-CA	BOLT
19	2	AN3-5A	BOLT
20	2	AN4-4A	BOLT
21	28	NAS1148C0332R	WASHER (AN680C10L)
22	2	NAS1148D0332J	WASHER (AN680J10L)
23	2	NAS1148D0416J	WASHER (AN680J1416L)
24	38	AE1S-1032-130	INSERT
25	2	AL57-428-165	INSERT
26	68	CR3212-5-05	CSK RIVET, CHERRY MAX

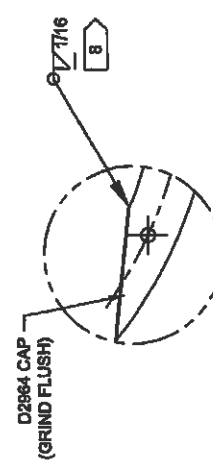
NOTES:
1) MATERIAL: NIA
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.6.1) PER DART QSI 005 4.3.
ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: NIA
6) IDENTIFICATION: NIA
7) WEIGHT: 18.2 lbs
8) WELDING: PER DART QSI 004.
9) INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SKAPLEX-2411-281 ADHESIVE PER DART QSI 018 AFTER BENDING.
10) USE DART DRILL TEMPLATE DT9800 TO LOCATE AND DRILL Ø0.287 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (38 PLACES) AFTER FINISH SEAL WEARPLATE BOLTS IN INDICATED LOCATIONS
11) DO NOT INSTALL AN3CA BOLTS AND NAS1148C0332R WASHERS IN INDICATED LOCATIONS
12) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø0.181 THRU SKIDTUBE AND DOUBLER USING DT10308.
COUNTERSINK Ø0.286 x 100" (34 PL) PER DOUBLER AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS.

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2017-08-11
EJ17-547

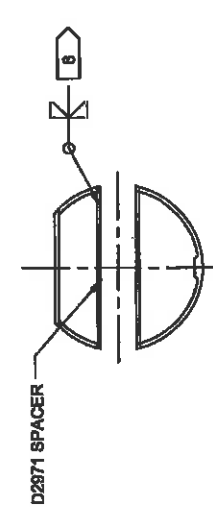
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WORK ORDER
NO. 601619 H15
19-10-08

E	MOVE VIEWS FROM SHT 1 TO SHT 2. ADD ITEMS 17 & 26 AND NOTE 12-13. Ø0.187 HOLE WAS Ø0.75. ADD SHT 3. ADD DETAIL J. SECTION F-F ADD D5520-1. SCALE ON VIEWS WAS 3X.	AJS	17.03.27
D	D3504-1 WAS D2873. REVISE BOM & SECTION F-F & SECTION NOTES (ZN B7-3, A5-3). REF NCR184180	RF	17.01.09
C	D3482 PLUG ASSEMBLIES REMOVED. REFORMAT NOTES SHT 1	AP	15.11.02
B	29.88 WAS 29.87 (ZN C2-1). INCORPORATED DED D3582-A-1 (ZN D5-1). FORMAT TO CURRENT STD	RF	15.02.20
A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	AJS		
CHECKED	MA		
MFG. APPR.	DD		
APPROVED			
DE APPR.			
DATE	17.03.27		
DART AEROSPACE USA, INC			
EUGENE, OR			
DRAWING NO. D3582			
SHEET 1 OF 4			
TITLE			
BK 117 SKIDTUBE ASSEMBLY			
SCALE			
NTS			
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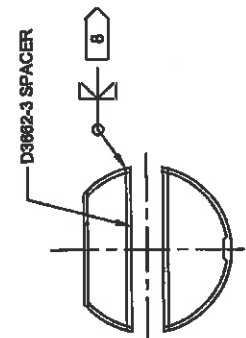


DETAIL C
SCALE 4X



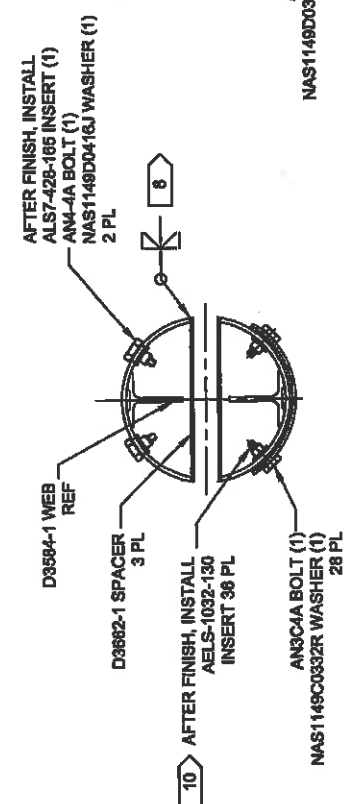
SECTION D-D
SCALE 4X

SECTION D-D NOTES
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
2. INSERT D2871 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.750 DRILL TO REMOVE SPILL OVER



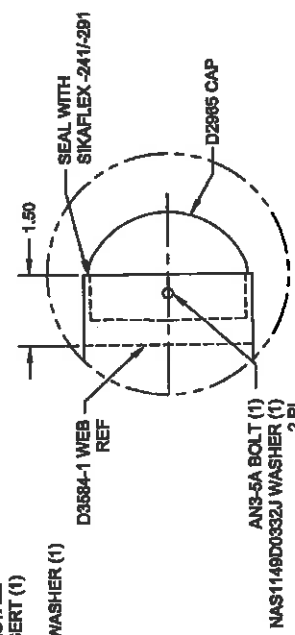
SECTION E-E
SCALE 4X

SECTION E-E NOTES
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3862-3 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.872 DRILL TO REMOVE SPILL OVER

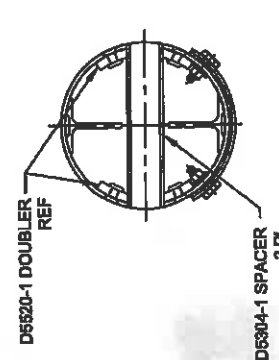


SECTION G-G
SCALE 4X

SECTION G-G NOTES
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3862-1 SPACER (3 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.515 DRILL TO REMOVE SPILL OVER



DETAIL H
SCALE 4X



SECTION F-F
SCALE 4X

SECTION F-F NOTES
AFTER BENDING AND DRILLING ASSY
PERFORM THE FOLLOWING:
1. INSERT D5304-1 SPACER
2. SWAGE TO Ø0.585 +0.005/-0.000 X 1.0
3. DEEP PER QSI 002
4. GRIND FLUSH

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	AUS	EUGENE, OR
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. E
MFG. APPR.		D3582 SHEET 3 OF 4
DE APPR.	<i>[Signature]</i>	TITLE SCALE
DATE	17.03.27	BK 117 SKIDTUBE ASSEMBLY NTS

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No.

[illegible]